Front Bulkhead

Replacement

1. Remove the related parts.
   - Front bumper
   - Right and left headlights
   - Right and left front fenders
   - Radiator, condenser
   - Hood latch

2. Roughly pull out and straighten the damaged area.
   - Check the damage to the front wheelhouse and front side frame before removing the front bulkhead. Use the frame straightener to roughly pull out and repair the damaged bulkhead before removing the bulkhead.

   NOTE: Check the fit of the door, taking care not to pull the damaged area out more than necessary.

   - Use the horizontal pinch weld clamps and attach the vehicle to the frame straightener at the clamping points securely.

3. Keep the body level.
   Jack up the body, and place safety stands at the four designated places of the side sills.

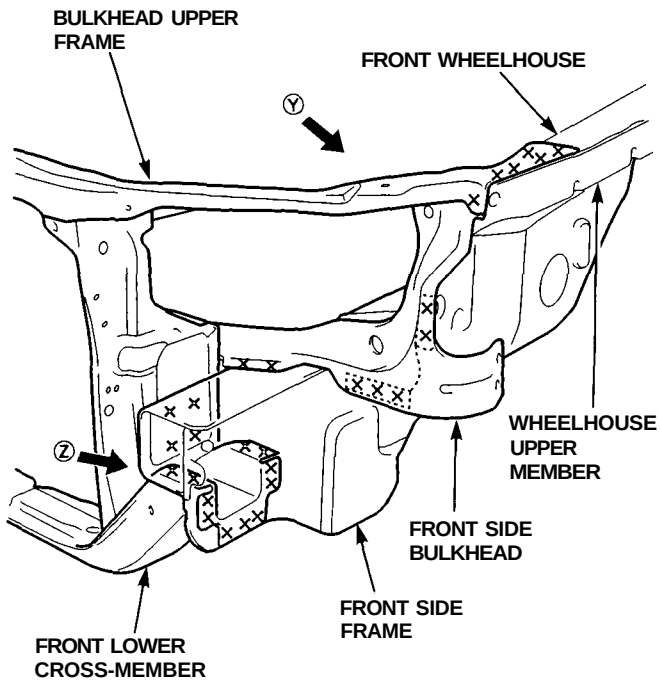
   NOTE: Refer to the Accord Service Manual for safety stand location points.

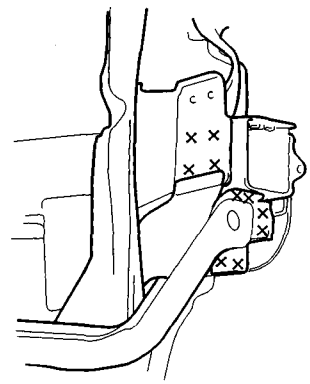
4. Cut and pry off the front bulkhead.
   - Center punch around the spot weld imprints.
   - Use the special spot cutter to drill holes at the spot weld nuggets on the front wheelhouse and front side frame.

   NOTE: When drilling holes, be careful not to drill through the front wheelhouse or front side frame.

   - Cut off the bulkhead with an air chisel, leaving the weld flanges intact.
   - Level and finish the burrs from the pried off spot welds with a disc sander.

⚠WARNING To prevent eye injury, wear goggles or safety glass whenever sanding, cutting or grinding.





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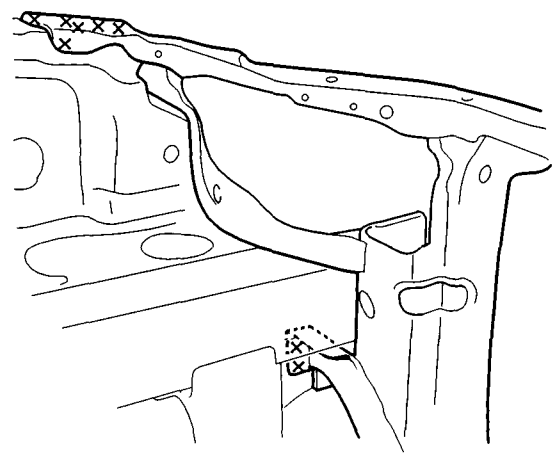

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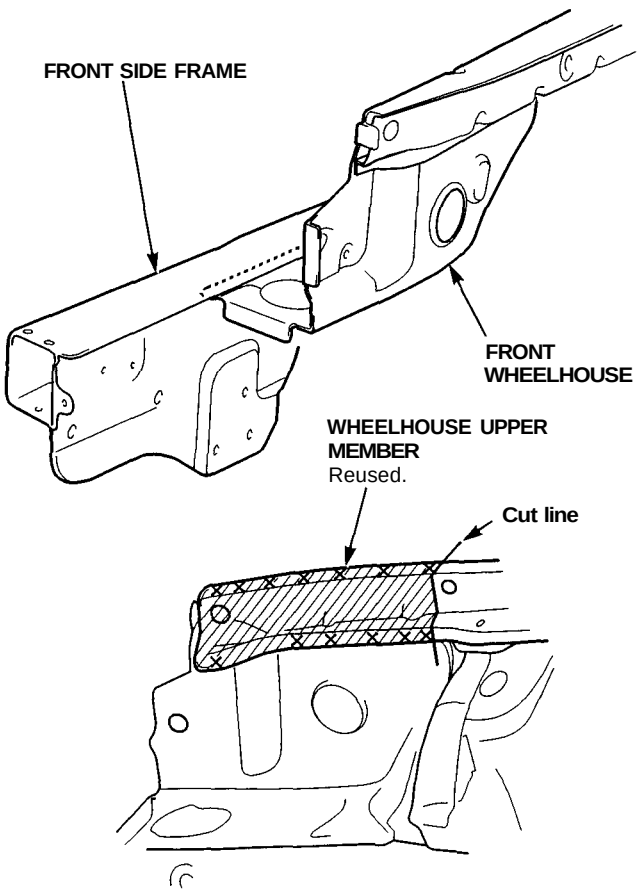
5. Check the front side frame, front wheelhouse, and wheelhouse upper member for position and damage.
If necessary, cut and pry off the wheelhouse upper.member with a die grinder.



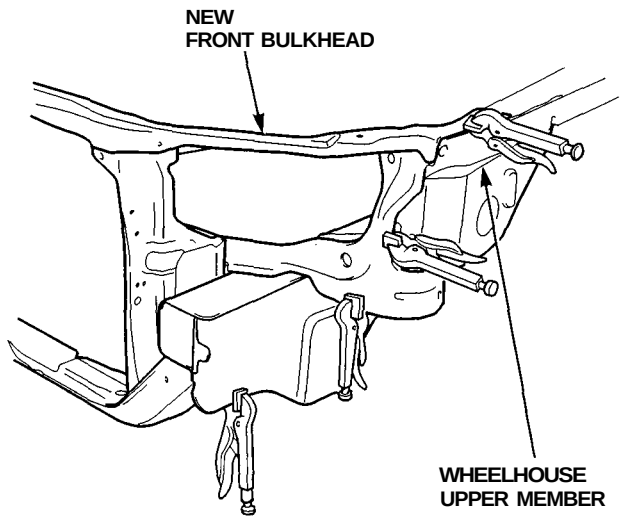
6. Straighten the damaged related parts.
   - Use a hammer and dolly to mold the damaged areas of the front wheelhouse and side frame.
   - Even out the welding flanges with a hammer and dolly.
   - Fill all drilled holes by MIG or gas welding.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

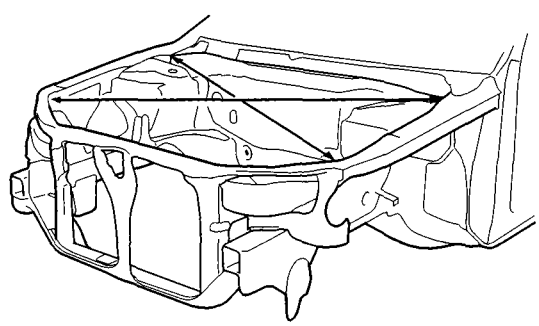
7. Set the new front bulkhead and wheelhouse upper member.
   - Grind both sides of the welding section of the bulkhead with a sander to remove the undercoat and to expose the steel plate.
   - Clamp both the right and left sides with the vise-grips.

NOTE: Apply the spot sealer to the welding surface when spot welding.

   - Check the front bulkhead position using the body dimensional drawings (see section 6).



8. Measure the front compartment diagonally with a tracking gauge or convex tool as shown to check it for twisting or bending.



(cont'd)

Front Bulkhead

Replacement (cont'd)

9. Remove the wheelhouse upper member.

10. Tack weld the new front bulkhead.

⚠ WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**

Spot weld the clamped sections.

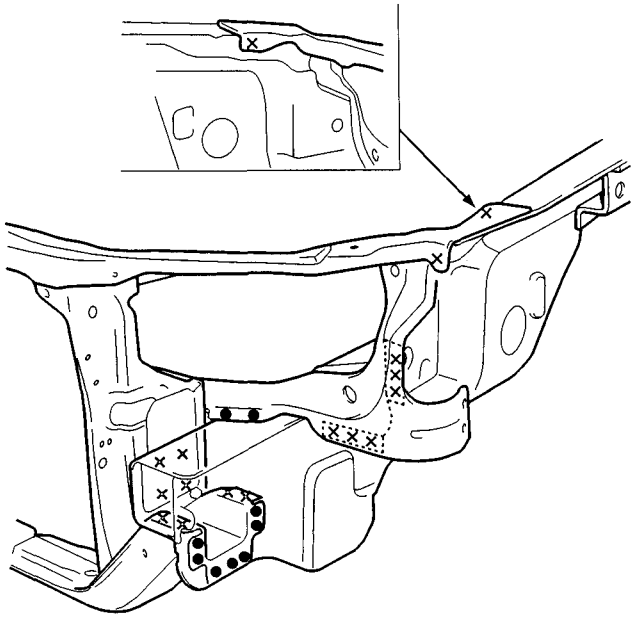
NOTE: Make sure that the right and left bulkheads are in line with each other.

11. Temporarily assemble the hood, headlight, front fender and front bumper, then check the clearances and level differences.

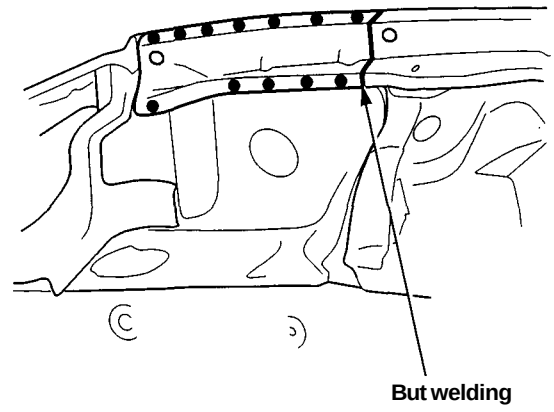
12. Perform the main welding.
- Spot weld the bulkhead as shown.
- Make 20% to 30% more spot welds than there were holes drilled.

NOTE: If there isn't room for spot welds, compensate by using MIG welds.

⚠ WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**



13. Weld the wheelhouse upper member.



But welding

14. Finish the welds. Use a hammer and dolly to even out the front wheelhouse gusset, front wheelhouse and front side frame flanges for a close fit with the surface of the front bulkhead.

15. Apply the undercoat (see section 7).

16. Attach the front fender.

17. Lower the body.

18. Apply the paint. See Paint Repair section.

⚠ WARNING
- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**

19. Install the related parts.

20. Inspect, check, and make adjustments.
- Adjust the headight aim.
- Check that the electrical components light up and operate properly.
- Replenish radiator coolant and inspect for leaks.